



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2804-041
Job Sheet 172092



Part No: D2804-041

Job Qty: 6 ea

Part Name: Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/12/18

Job Tracking No:

Due Date: 2/19/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV D IPP F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM IPP Rev:G As per Rev C 06-11-08 JLM IPP REV:H 16.06.23 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	2/17/18	2/17/18	0.00	0.00	Start Up Small Fab-1		
100	Small Fab	6 pcs	2/17/18	2/17/18	0.00	0.48	Small Fab-2		
110	QC	6 pcs	2/17/18	2/17/18	0.00	0.00	QC5		
120	Powdercoat	6 pcs	2/17/18	2/17/18	0.00	0.37	Powdercoat1		
130	QC	6 pcs	2/17/18	2/17/18	0.00	0.00	QC3		
150	Small Fab	6 pcs	2/19/18	2/19/18	0.00	0.48	Small Fab-2		
160	QC	6 pcs	2/19/18	2/19/18	0.00	0.00	QC5		
170	Packaging	6 pcs	2/19/18	2/19/18	0.00	0.00	Packaging3-1		
180	QC21-SA	6 Ea	2/19/18	2/19/18	0.00	0.00	QC21		

Part Op 100 - Press D2805-1 and D2809 Into arm as per Dwg D2804

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

120 - White Gloss (Ref 4.3.5.1) per QSI005 4.3-Alum START TIME: 3:25 OVEN TEMPERATURE: 320°

FINISH TIME: 3:55 M 139467

130 - QC3- Inspect Part Finish

150 - 1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 2-Assemble as per Dwg D2804.

160 - QC5- Inspect part completeness to step on W/O

170 - Identify as per dwg & Stock Location:

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2804-1	Bracket	6 Ea (1 ea)	90-Start up Operation	F163441 4x F151248 2x
D2805-1	Stop	6 Ea (1 ea)	90-Start up Operation	F162357
D2809	Washer	6 Ea (1 ea)	90-Start up Operation	F1512443 F138750
AN3C16A	Bolt	12 Ea (2 ea)	150-Small Fab	F1512443 F138750
D3672-15	Phenolic Washer	24 Ea (4 ea)	150-Small Fab	F1512443 F138750
MS21043-3	Nut	12 Ea (2 ea)	150-Small Fab	F1512443 F138750

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2804-1	6	6	0
	D2805-1	6	12	0
	D2809	6	27	0
150-Small Fab	AN3C16A	12	40	0
	D3672-15	24	3	0
	MS21043-3	12	1,206	0

60/201

Plex 2/12/18 1:53 PM Dart.Gagnon.Michelle

Part Specifications

Specifications could not be found.

Plex 2/12/18 1:53 PM Dart.Gagnon.Michelle

**Container No: S044593****Part: D2804 – 041****Job No: 172092****Serial No/Batch: S044593****Revision: D2804****Inspector:**

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/22/18

SHOP COPY

RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

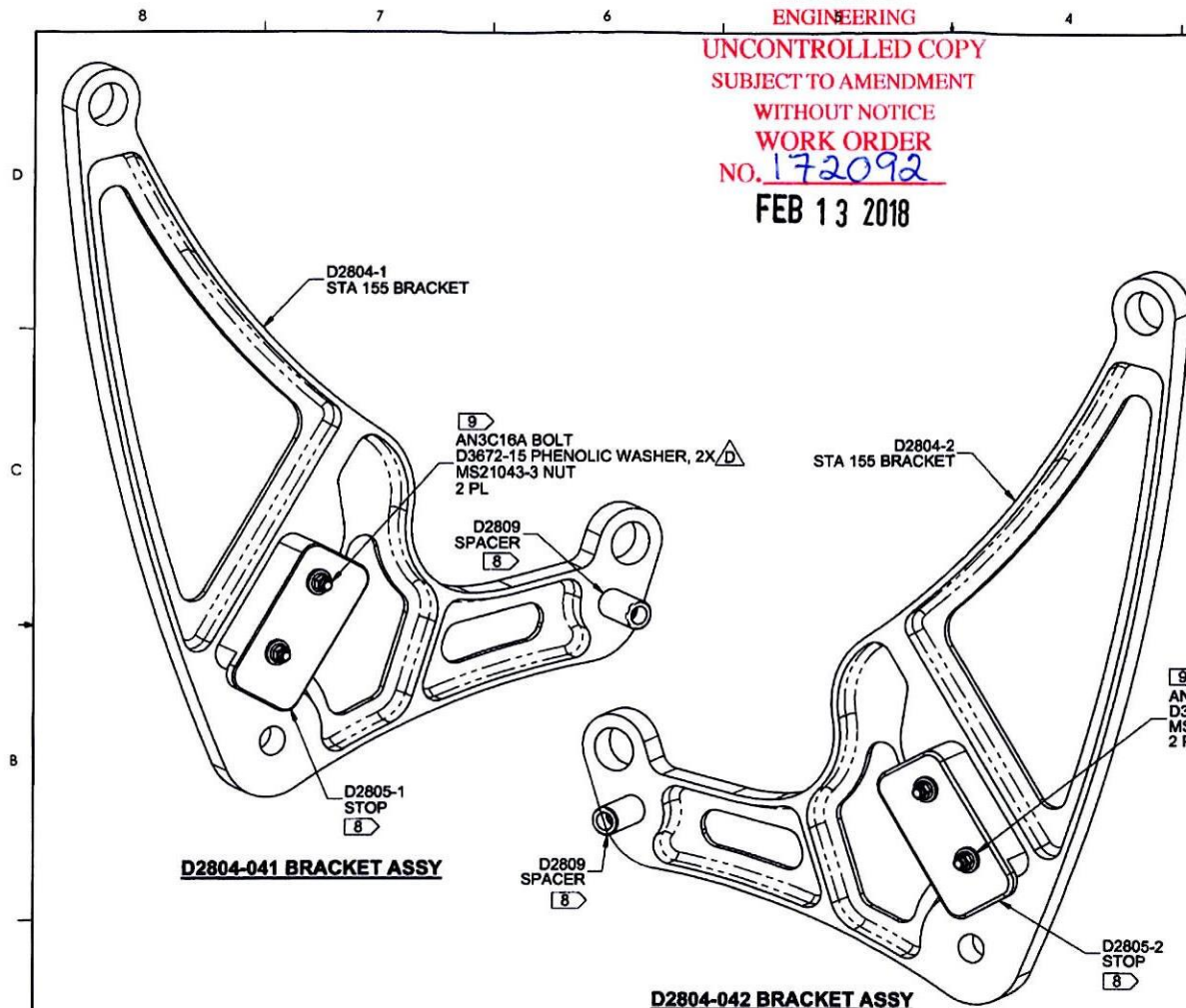
WITHOUT NOTICE

WORK ORDER

NO. 172092

FEB 13 2018

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
	X		D2804-041	BRACKET ASSY
		X	D2804-042	BRACKET ASSY
1	1		D2804-1	STA 155 BRACKET
2		1	D2804-2	STA 155 BRACKET
3	1		D2805-1	STOP
4		1	D2805-2	STOP
5	1	1	D2809	SPACER
6	4	4	D3672-15	PHENOLIC WASHER
7	2	2	AN3C16A	BOLT
8	2	2	MS21043-3	NUT, SELF-LOCKING



D2804-041 BRACKET ASSY

D2804-042 BRACKET ASSY

NOTES:

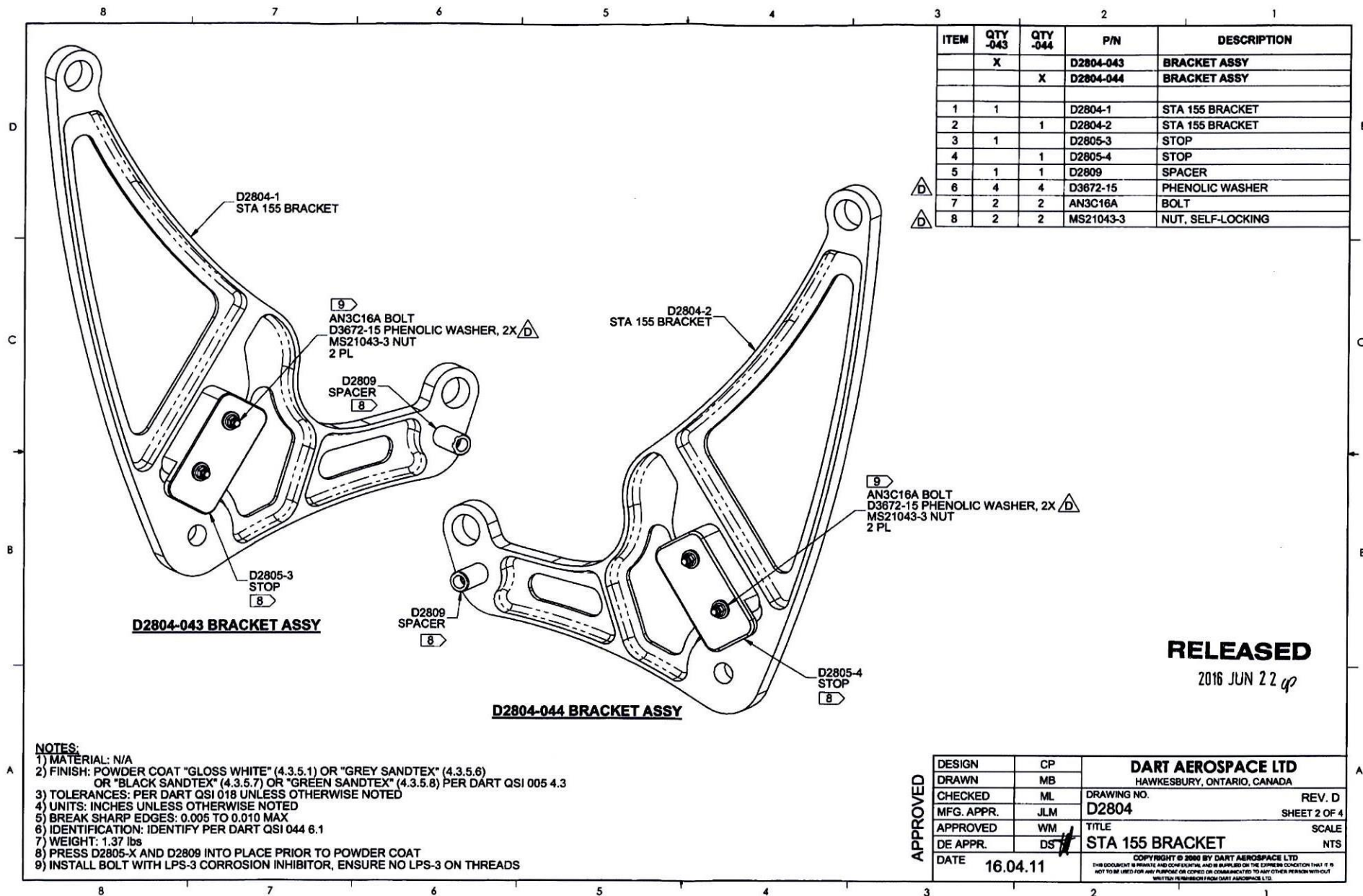
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GLOSS WHITE" (4.3.5.1) OR "GREY SANDEXT" (4.3.5.6) OR "BLACK SANDEXT" (4.3.5.7) OR "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 6.1
- 7) WEIGHT: 1.37 lbs
- 8) PRESS D2805-X AND D2809 INTO PLACE PRIOR TO POWDER COAT
- 9) INSTALL BOLT WITH LPS-3 CORROSION INHIBITOR, ENSURE NO LPS-3 ON THREADS

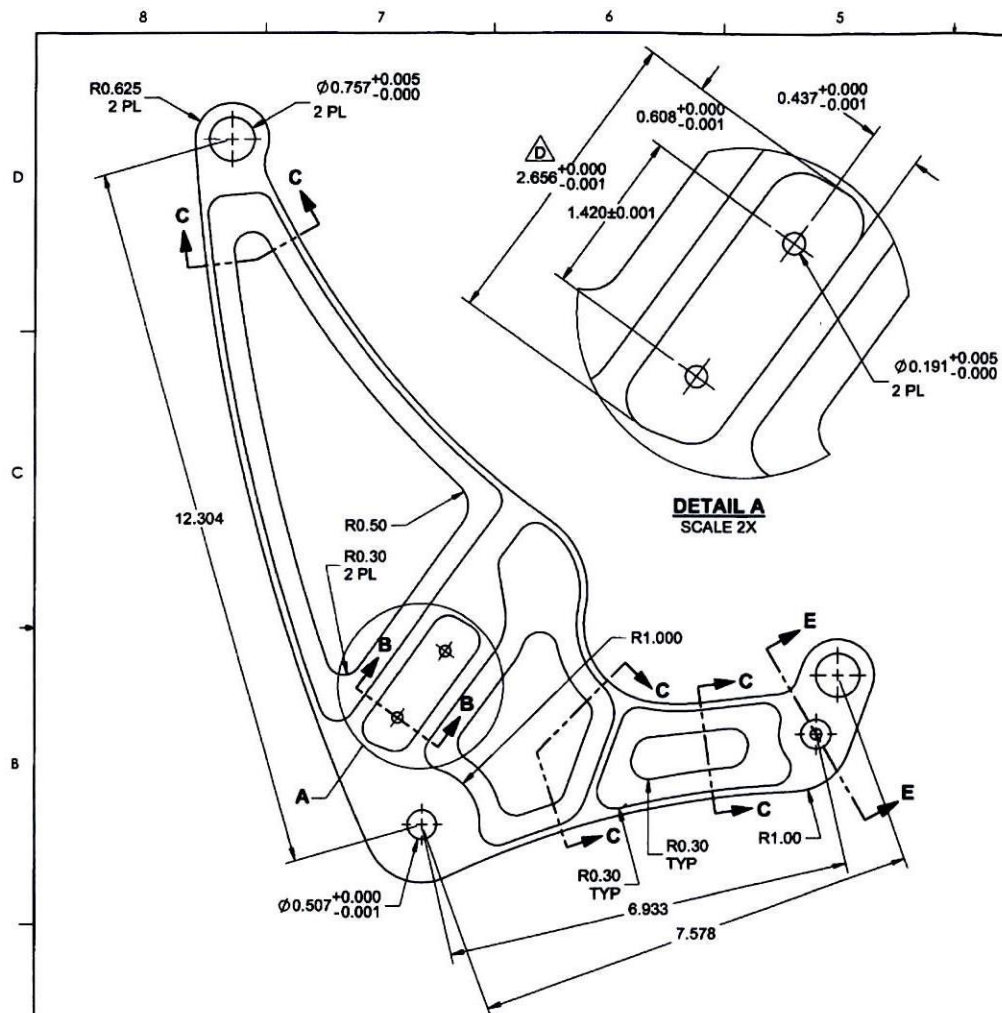
RELEASED

2016 JUN 22
ECN 16-661

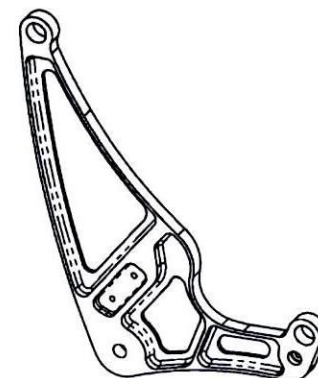
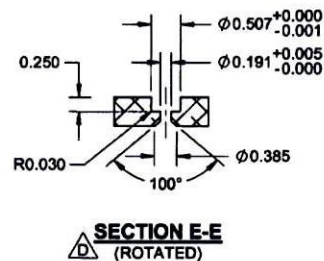
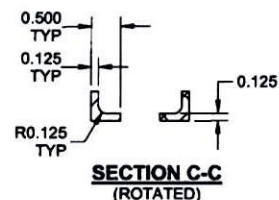
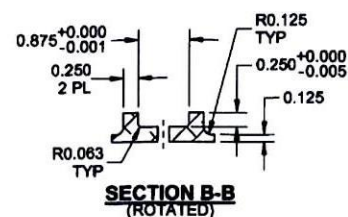
D	REVISE TO CURRENT FORMAT; D3672-15 WAS NAS1515A3; MS21043-3 WAS MS21042-3; ADD CSINK (SECTIONS E-E AND J-J). REF: PAR16-499 D6-3/4: 2.856 WAS 2.854 REASON: CAD ERROR.	MB	16.04.11
C	CHANGE GEOMETRY TO ADD CLEARANCE	CP	06.10.16
B	ADD CUTOUTS AND -043/-044	CP	04.11.22
A	NEW ISSUE	CP	00.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	JLM	D2804	SHEET 1 OF 4
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STA 155 BRACKET	NTS
DATE	16.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED





DETAIL A
SCALE 2X



D2804-1 STA 155 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M8061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: R0.030 TO 0.063 ON ALL EDGES
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.01 lbs
- 8) MACHINE PER PART FILE D2804-1_REV.D.SLDPRT

APPROVED	DESIGN	CP	DART AEROSPACE LTD	
	DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
	CHECKED	ML	DRAWING NO.	REV. D
	MFG. APPR.	JLM	D2804	SHEET 3 OF 4
	APPROVED	WM	TITLE	SCALE
	DE APPR.	DS	STA 155 BRACKET	NTS
	DATE	16.04.11	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED

2016 JUN 22 qf

